

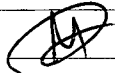
Work Order ID 126921

126921

Page 1

Monday, December 01, 2014 11:33:29 AM

Item ID: D3822-7KGY Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Vertical Tunnel, Lower-Grey
 Start Date: 11/27/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/02/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: 11-12-1 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|-----|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3822-7 | Rev. C | | | | | | | | DAS |

100 0.00 07 9-89

100

HandThermo Memo 0.00 x/ 17/12/16

Hand Finishing Thermoforming 1-Cut Sheet to required Blank size

105 0.00 07 9-89

105

HandThermo Dry Material Memo 0.00 x/ 17/12/16

Hand Finishing Thermoforming Dry Sheet as per QSI022 KYDEX

Temp: 153 deg

Time IN: 5:00

Time OUT: 6:00

DEC 15 2014

...

Work Order ID 126921

Monday, December 01, 2014 11:33:29 AM

126921

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Item ID: D3822-7KGY Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Vertical Tunnel, Lower-Grey
 Start Date: 11/27/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/02/14 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamps |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------|
| 110 | | 0.00 | | | | | | | 07 9-89 |

110

Thermoform

Thermoforming Machine

Memo

- 1-Machine Set-Up
- 2-Pre-heat Tool to required temp.
- 3-Thermoform as per Dwg and Folio #FTA029 using tool DT9396

Dwg Rev: C

Folio Rev: B

Visually inspect for proper formation of each part

140

0.00

140

HandThermo

Hand Finishing Thermoforming

Memo

- 1-Trim to finished dimensions as per Dwg

DAS
07
9-89

14/12/18.

Monday, December 01, 2014 11:33:29 AM

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| | | | | |
|--------------|---|------|------|-------------|
| 170 | Identify as per dwg & Stock Location: <u>1W</u> | 0.00 | 9-89 | DEC 18 2014 |
| *170* | | | | |
| Packaging | Memo | 0.00 | | |
| Packaging | | | | |

Work Order ID 126921

Monday, December 01, 2014 11:33:29 AM

126921

Page 4

Item ID: D3822-7KGY

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vertical Tunnel, Lower-Grey

Start Date: 11/27/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | QC21 - Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14/12/18 *[Signature]**[Signature]* 12-18

Picklist Print

Page 1

Monday, December 01, 2014 11:33:29 AM

Work Order ID: 126921

126921

Parent Item: D3822-7KGY

D3822-7KGY

Parent Item Name: Vertical Tunnel, Lower-Grey

Start Date: 11/27/14

Required Date: 12/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

lpp Rev. B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

MKYD6185S.080-P3-
52068

Purchased

No

100

sf

3,800.000

2.16

3

DAS
07
9-89

MKYD6185S 080-P3-52068

Kydex steel grey (52"x96"-.080)

Location

Loc Qty

Loc Code

LAIRD

1180

m129546

347

m129760

347

m130383

486

therm

2620

119476

61

121902

819

122181

1046

m127759

347

m128321

347

350 PL

12/12/18

| | | | |
|--|---------------|---------------------|----------------|
| DART AEROSPACE LTD | | Work Order: | 126921 |
| Description: Vertical Tunnel, Lower | | Part Number: | D3822-7KIV/KGY |
| Inspection Dwg: D3822 | Rev: C | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than <u>N/A</u> | | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |

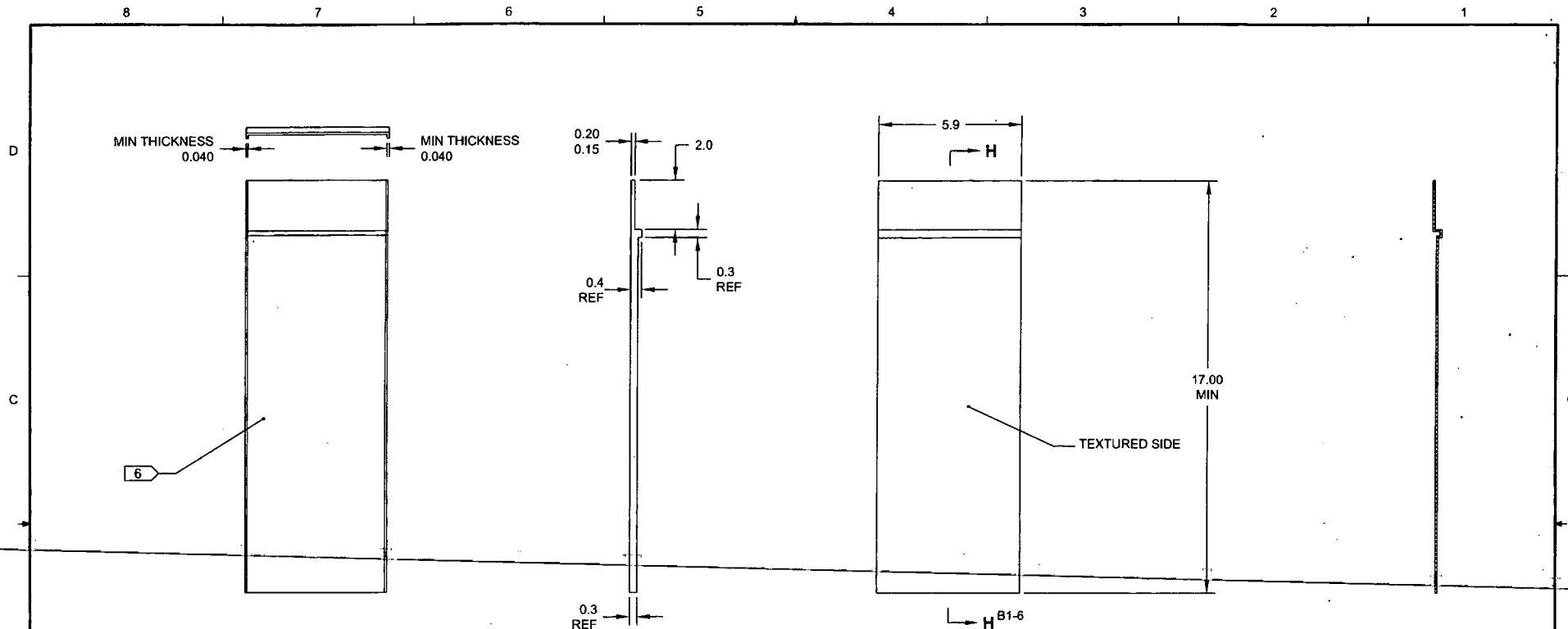
| | | | |
|---------------------|---------------------------------|--------------|----------|
| Measured by: | DAS 07 9-89 | Date: | 14/12/16 |
|---------------------|---------------------------------|--------------|----------|

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.20 - 0.15 | Min | 0.23" | ✓ | | | |
| 0.060 | Min | 0.073" | ✓ | | | |
| | | | | | | |
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| | | | |
|----------------------------|---------------------------------|--------------|-------------|
| Measured by: | DAS 07 9-89 | Date: | |
| Audited by: | DAS 38 9-89 | Date: | DEC 18 2016 |
| Prototype Approval: | N/A | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 09.07.29 | New Issue | KJ | |



D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

SECTION H-H B3-6

RELEASED
09/05/22

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED



| PART NUMBER | DESCRIPTION |
|-------------|--|
| D3822-7KIV | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015) |
| D3822-7KGY | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |

| | | | |
|---|----------|--|--------------|
| DESIGN | RA | DART AEROSPACE LTD | |
| DRAWN | RA | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RA | DRAWING NO. | REV. C |
| MFG. APPR. | RA | D3822 | SHEET 6 OF 6 |
| APPROVED | RA | TITLE | SCALE |
| DE APPR. | RA | VERTICAL TUNNEL (BELL 206 A/B) | NTS |
| DATE | 09.05.05 | COPYRIGHT © 2006 BY DART AEROSPACE LTD | |
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